

**Work Order ID 62428**

September 30, 2010 7:59:49 AM



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Item ID: D4172-4

Accept



Setup Start



Revision ID:

Item Name: Support Angle

Stop



Start Date: 9/30/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/08/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 10/9/30

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4172	A

100

0.00

M-1 10/09/30



Small Fab

Memo

0.00

Small Fab

- 1- Cut to lenght as per dwg
- 2- Use DT9658 to drill holes in angle, open to size as per dwg
- 3- C'sink holes as per dwg
- 4- Deburr holes

(X)

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S.10/10/06

P10 →

120



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

BF 10-10-6

(X)

-4

(O)

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4172-4 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 62428		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.10.01	100.2	# HOLE SERVED PER DETAIL A SHIFTED BY 0.030" ON THE 5.500" DM (C8-G7). RC: JIG NOT PROPERLY PREPARED.	10.10.01	THIS DEVIATION IS ACCEPTABLE ON THE BASIS THAT <del>ALL</del> ALL THE HOLES ARE STILL WITHIN <del>0.010"</del> 0.010" FROM	M/A 10/10/01	S 10/10/01	S 10/10/01	S 10/10/01
		AT THE END STOPPER, FLASH OF WELDING PREVENTING FROM LOCATING PART CORRECTLY.	10.10.01	BASH OTHER , FOR DRAWING. FURTHERMORE, THERE IS EXCESS PEAK IN THE NUTPLATES TO COMPENSATE.		S 10/10/01	S 10/10/01	S 10/10/01
10/10/01	# 100	Found at inspection that Dim .563 was measuring from one end .553 and the other .583. R.C. Jig is off.	10.10.04	SCRAP PART. CONVERT OR MAKE NEW DRILLING JIG PRIOR TO MARKING REPLACEMENT FOR SCRAPPED PART.	10.10.04 M/A 10/10/01	S 10/10/01	S 10/10/01	S 10/10/01

NOTE: Date & initial all entries

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Start Date: 9/30/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/08/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC3- Inspect Part Finish

0.00

7/4/

10/10/06

1 0



QC

Quality Control

140

Identify as per dwg & Stock Location: 21A

0.00



Packaging

Packaging

Memo

0.00

10/10/06 SP

150

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

10/10/06 SP
MF  
10-10-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 62428



Parent Item: D4172-4



Parent Item Name: Support Angle

Start Date: 9/30/10

Required Date: 10/08/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A1.000W.125		Purchased	No			100	f	90.9100	6.25	6.578947		m-f 10/09/30	

6061T6 ANGLE 1.00 x 1.00 x .125W



Location	Loc Qty	Loc Code
MAT	90.91	
115688 ✓	10.91	
115776	80	

6-578947

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

